

Work Order ID 139140

Thursday, December 03, 2015 12:52:11 PM

139140

Page 1

Item ID: PB67-43001-129

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Tube Handle

Stop

NS2

Start Date: 11/16/2015 Start Qty: 6.00

6

Cust Item ID:

Required Date: 12/4/2015 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: MCS

Date: DEC 03 2015

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

B67-43001

C

100

100

Doosan

Doosan Lathe

DOOSAN LATHE

Memo

1- Turn as per Dwg B67-43001

Dwg Rev: _____

2- Deburr

0.00

0.00

6

0

DAS
40
9-89

15/12/23

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

6

0

DAS
40
9-89

15/12/23

120

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

6

0

DAS
45
9-89

2015-12-23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Work Order ID 139140

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Page 2

Thursday, December 03, 2015 12:52:11 PM

Item ID: PB67-43001-129

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Tube Handle

Start Date: 11/16/2015 Start Qty: 6.00

6

Cust Item ID:

Required Date: 12/4/2015 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 Identify as per dwg & Stock Location: ME222

0.00

130

Packaging Memo

0.00

Packaging

6 JAN 04 2016 DAS
6
9-89

140 QC21- Final Inspection - Work Order Release

0.00

140

QC Memo

0.00

Quality Control

MLJ JAN 05 2016

MLJ JAN 04 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval				
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				OTHER : ☐							

Picklist Print

Thursday, December 03, 2015 12:52:15 PM

Page 1
/

Work Order ID: 139140

139140

Parent Item: PB67-43001-129

PB67-43001-129

Parent Item Name: Tube Handle

Start Date: 11/16/2015

Required Date: 12/4/2015

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A05.07.20New issueKJ/JLM
IPP Rev:B Now on Doosan Lathe 08-06-25 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.875W0.12 5		Purchased		No		100	f	0.3700	0.425	2.684211			DAS 40 9-89

M6061T6T0 875W0 125

15/12/23

6061-T6 RD TUBE .875 X .125W

Location

Loc Qty

Loc Code

MAT015

0.37

m132120

0.37

→ M133754

2.6

DQA: _____ Date: _____



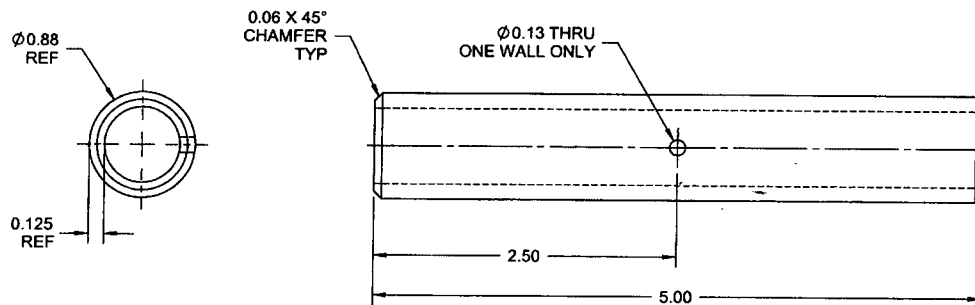
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QA Closed: _____ Date: _____

Work Order update only ☐

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B67-43001-129 TUBE HANDLE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

139-140 M/L

15-12-03

RELEASED
2009-09-24
MD

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING
PER WW-T-700/6 OR AMS4080 OR AMS 4082 OR
AMS-QQ-A-200/8 OR AMS-QQ-A-225/8
REF. DART SPEC. M6061T6T0.875W.125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.14 lbs

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 35 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.02.26
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED	AS	DRAWING NO.	REV. C	
MFG. APPR.	MD	B67-43001-129	SHEET 1 OF 1	
APPROVED	MD	TITLE	SCALE	
DE APPR.	N/A	TUBE HANDLE	NTS	
DATE	09.02.26	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		